

Work Order ID 86633

86633

Page 1

Friday, July 06, 2012 11:45:24 AM

Item ID: D4547-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Vertical Linkage, Bottom

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

MUF

Date: 12-04-06

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4547

B

100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

MACHINE AS PER DWG AND FOLIO FB102

DEBURR

DAS 13

12/7/13

2 *✓*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS 13

12/7/13

2 *✓*

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DRILL/MILL AS PER DWG

9/12-07-13

2 *✓*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86633

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Vertical Linkage, Bottom

Stop ***NS2***

Start Date: 7/5/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: ST118	0.00							
130									
Packaging	Memo	0.00				2x			80
Packaging									12-7-19
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							12/7/23
Quality Control									MF

12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Friday, July 06, 2012 11:45:24 AM

Page 1

Work Order ID: 86633
 Parent Item: D4547-3
 Parent Item Name: Vertical Linkage, Bottom

Start Date: 7/5/2012 Required Date: 7/19/2012
 Start Qty: 2.00 Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-01-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750 304 SS Roundbar .750		Purchased	No			100	f	34.6170	0.125	0.2631579			

Location	Loc Qty	Loc Code
MAT028	26.4	
116501	1.746	
116623	0.854	
121282	23.8	
MAT029	8.217	
117481	1.717	
118509	6.2	
120124	0.3	

303 ASD

122059

3 Lt 12/7/13

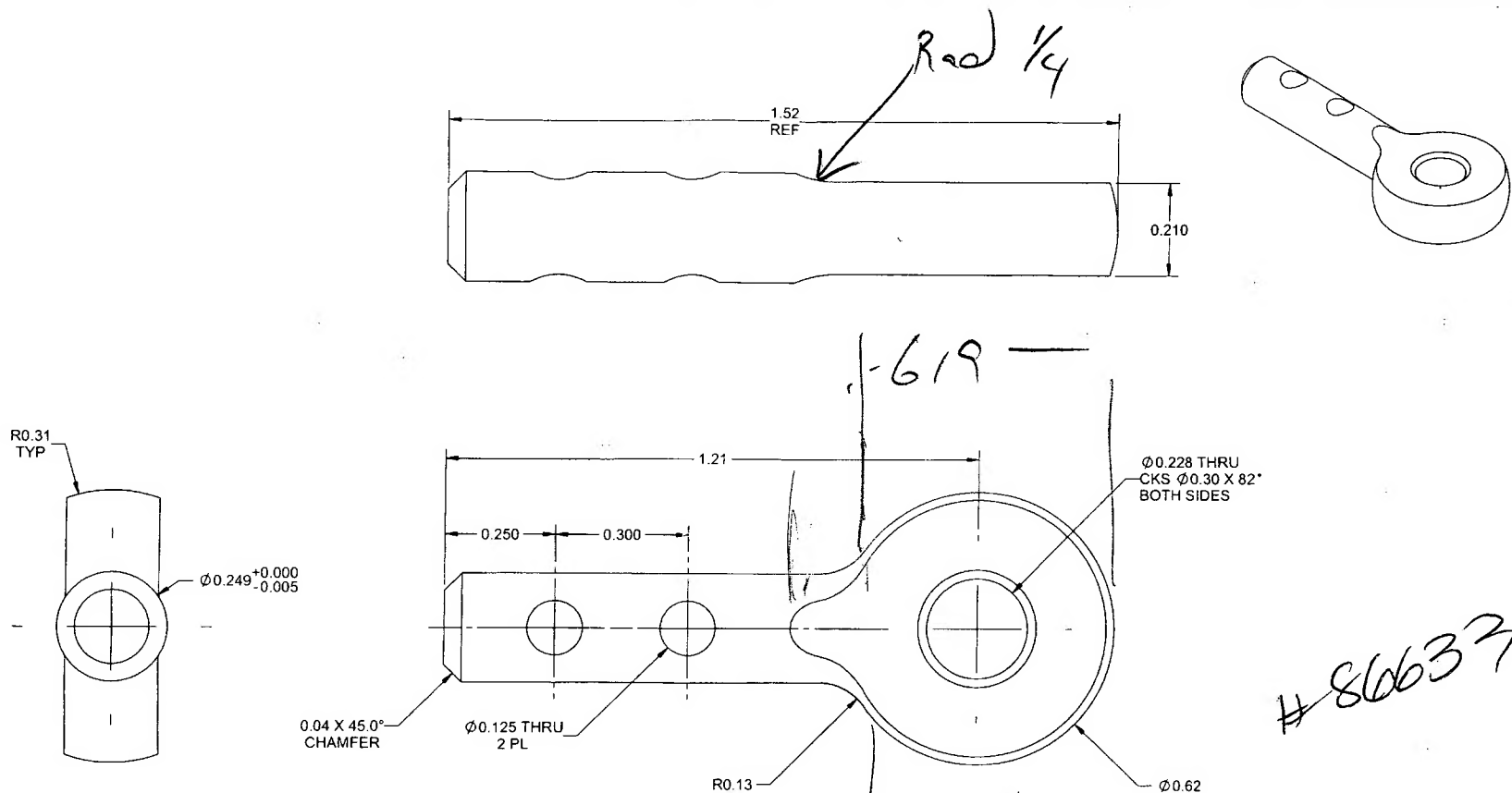


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D4547-3 VERTICAL LINKAGE, BTM

NOTES:

- 1) MATERIAL: AISI 303/304 SS BAR OR PLATE PER ASTM A582 OR A276 OR ASTM A240 REF: DART SPEC M303B OR M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	AR	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4547	REV. B
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE VERTICAL LINKAGE ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2012 BY DART AEROSPACE LTD	
DATE	12.04.19	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

#80633

RELEASED
2012-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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